

Work Order ID 114797

March-13-14 8:38:56 AM

114797

Page 1

Item ID: K642-511

Revision ID:

Item Name: Saddle 642-511

Start Date: 3/13/14 Start Qty: 3.00 *3*

Required Date: 3/27/14 Req'd Qty: 3.00 *3*

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 14-03-13

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-642	P

J.B.

100 Document Control
DOCUMENT CONTROL

100

DC

Memo

Doc.Control -USB or Paperwork

Create White labels per PPP K642-511

0.00

0.00

CHG005

MAY 06 2014

DAS
03
9-89

3

110 Pick Kit

110

Packaging

Memo

Packaging

0.00

0.00

DAS
33
9-89

1404-08

3

DAS
03
9-89

120 QC4- 100% Inspect kits for completeness

120

QC

Memo

Quality Control

0.00

0.00

MAY 06 2014

DAS
03
9-89

3

Work Order ID 114797

March-13-14 8:38:56 AM

114797

Page 2

Item ID: K642-511

Revision ID:

Item Name: Saddle 642-511

Start Date: 3/13/14

Start Qty: 3.00

3

Required Date: 3/27/14

Req'd Qty: 3.00

3

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPP K642-511 Location: PK143DAS
03
9-89

MAY 06 2014

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

14/5/14MF
14-5-6

Picklist Print

March-13-14 8:38:59 AM

Page 1

Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A07.06.05 new issueEC
IPP Rev.B 08.02.05 , Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-648-013

Manufactured No

110

Each

7.0000

1 3

D206-648-013

Ground Handling Wheel Modification

**

115113

DAS
37
9-22

DAS
06
9-23

Location
PKG013

Loc Qty

Loc Code

7

108084

3

110290

1

112884

3

110

Each

17.0000

1 3

D2932-1

Manufactured No

D2932-1

206 Saddle Left Side

**

DAS
33
9-23

14-04-08

Location
ST437

Loc Qty

Loc Code

17

107966

1

109162

7

112271

1

113054

6

88413

1

98161

1

109162

DAS
37
9-22

Picklist Print

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Page 2

Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

D2933-1

Manufactured No

110

Each

17.0000

1

3

D2933-1
206 Saddle Left

DAS
33
9-89

DAS
33
9-89

Location

Loc Qty

Loc Code

ST437

10

108888

2

109165

4

112551

4

ST438

6

113216

6

ST446A

1

98159

1

110

Each

20.0000

1

3

D2938-1
206 Saddle Left Side

DAS
33
9-89

14-0408

DAS
33
9-89

Location

Loc Qty

Loc Code

ST438

11

107691

1

108897

2

113227

4

113838

4

ST447

9

106453

2

109164

6

98163

1

1+167691
2+108897

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Shop Packet Print

Page 2

Picklist Print

March-13-14 8:38:59 AM

Page 3

Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

D2939-1

Manufactured No

110

Each

20.0000

1 3

D2939-1

206 Saddle Left Side

**

DAS

33

9-89

DAS

00

9-89

Location

Loc Qty

Loc Code

ST438

19

109168

4

112275

5

113056

6

113617

4

ST447

1

98165

1

110

Each

180.0000

8 24

**

DAS

33

9-89

AN3C41A

Purchased

No

AN3C41A

Bolt

DAS

03

9-89

Location

Loc Qty

Loc Code

FG

10

103324

4

122843

6

ST353

170

m127544

1

m128319

169

DAS

31

9-89

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Shop Packet Print

Page 3

Picklist Print

March-13-14 8:39:00 AM

Page 4

Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

D2652

Manufactured No

110

Each

1,231.000

16

48

D2652

Bushing

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

44

31985

44

ST014

1187

103022

50

103643

201

110800

200

113196

400

113796

336

167113196

327113796

110

Each

1,262.000

20

60

MS21043-3

Purchased

No

MS21043-3

Nut

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

182

124555

43

m126741

139

ST509

1000

m128398

1000

128398

DAS

31

9-89

14-04-08

March-13-14 8:39:00 AM

Shop Packet Print

Page 4

Picklist Print

March-13-14 8:39:00 AM

Page 5

Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

D3672-7

Manufactured No

110

Each

1,373.000

24

72

DAS
33
9-89

D3672-7

Phenolic Washer

DAS
03
9-89

Location

Loc Qty

Loc Code

FG

25

93370

25

ST060

1348

103641

541

111568

307

113195

500

103641

DAS
31
9-89

AN5C11A

Purchased No

110

Each

265.0000

8

24

DAS
33
9-89

AN5C11A

Bolt

DAS
03
9-89

Location

Loc Qty

Loc Code

FG

4

103715

4

ST362

177

M127933

27

M128403

150

st503

84

M126105

49

M127817

35

128403

DAS
31
9-89

AN5C12A

Purchased No

110

Each

67.0000

4

12

DAS
33
9-89

AN5C12A

BOLT

DAS
03
9-89

Location

Loc Qty

Loc Code

FG

2

18918

2

ST362

65

M127290

15

M127815

50

127815

DAS
31
9-89

March-13-14 8:39:00 AM

Shop Packet Print

Page 5

Picklist Print

March-13-14 8:39:00 AM

Page 6

Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

AN5C13A

Purchased

No

110

Each

163.0000

4 12

**

DAS

33

9-89

AN5C13A

BOLT

DAS
03
9-89

Location

Loc Qty

Loc Code

ST362

38

120562

38

4x120562

st503

75

M127363

75

ST516

50

M126105

50

8x126105

110

Each

360.0000

8 24

**

DAS

33

9-89

NAS1149C0532R

Purchased

No

NAS1149C0532R

WASHER

DAS
03
9-89

Location

Loc Qty

Loc Code

GA

55

116513

55

ST292

305

m126319

305

126319

110

Each

981.0000

12 36

**

DAS

33

9-89

AN4C6A

Purchased

No

AN4C6A

Bolt

DAS
03
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

ST355

667

m125709

167

m128324

500

11x125709

28x128324

ST517C

300

m128403

300

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Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

D3672-3

Manufactured No

110

Each

1,803.000

24

72

D3672-3

Phenolic Washer

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

111

84432

11

89273

100

FP001

63

107316

63

ST060

1628

110251

128

112455

500

113746

1000

ST061

1

93925

1

NAS1149C0432R

Purchased

No

110

Each

4,716.000

24

72

NAS1149C0432R

WASHER

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

GA

1959

m125807

1959

ST292

92

119124

6

121255

7

122441

79

ST510a

2665

m126221

2665

DAS

31

9-89

March-13-14 8:39:00 AM

Shop Packet Print

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Picklist Print

March-13-14 8:39:00 AM

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Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

110

Each

1,658.000

13

39

MS21043-4

Nut

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

33

125807

33

ST315

512

m123021

12

m128429

500

ST509

1073

m127255

73

m128300

1000

128429

D3407-043

Manufactured

No

110

Each

13.0000

1

3

D3407-043

Tow Ring

DAS

33

9-89

113211

14-04-08

Location

Loc Qty

Loc Code

ST446

4

103303

4

ST463

9

106890

2

108105

2

112541

5

DAS

33

9-89

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Picklist Print

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Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

D3456-1

Manufactured No

110

Each

194.0000

1 3

D3456-1

Washer

**

DAS
33
9-89

DAS
05
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST046

187

107629

1

111782

100

113126

86

110

Each

875.0000

10

30

D2712

Manufactured No

D2712

Set Screw

**

DAS
33
9-89

1404-08

DAS
05
9-89

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

825

101775

55

107365

2

108882

18

110809

150

112534

100

113205

200

113809

300

DAS
31
9-89

113205

March-13-14 8:39:00 AM

Shop Packet Print

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Picklist Print

March-13-14 8:39:00 AM

Page 10

Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

D3457-1

Manufactured No

110

Each

51.0000

2 6

D3457-1

Washer

**

113632

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST046

41

109133

16

83268

2

99638

23

DAS

31

9-89

D2934

Manufactured No

110

Each

36.0000

2 6

D2934

Saddle Spacer

**

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

30

106671

4

108742

2

112252

24

DAS

31

9-89

D2935

Manufactured No

110

Each

21.0000

2 6

D2935

Saddle Spacer

**

113208

DAS

33

9-89

14-04-08

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

15

111577

15

DAS

31

9-89

March-13-14 8:39:00 AM

Shop Packet Print

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Picklist Print

March-13-14 8:39:00 AM

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Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

AN3C36A

Purchased

No

110

Each

256.0000

9 - 27

AN3C36A

Bolt

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

25

101261

4

122204

11

124827

10

ST514

231

m127769

81

m128398

150

110

Each

92.0000

3 9

AN3C35A

Purchased

No

AN3C35A

Bolt

DAS

33

9-89

14-04-08

Location

Loc Qty

Loc Code

FG

4

18914

4

ST352

88

M125958

3

M127745

25

M127746

35

M128398

25

4x127745
5x127746

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0332R

Purchased

No

110

Each

6,712.000

24

72

DAS

33

9-89

NAS1149C0332R

WASHER

**

128591

Location

Loc Qty

Loc Code

GA

1089

125654

1089

st510

5623

m126319

61

m127306

2500

m127410

3000

m127831

62

DAS

31

9-89

D3396-3

Manufactured

No

110

Each

77.0000

2

6

DAS

33

9-89

D3396-3

Bushings

**

Location

Loc Qty

Loc Code

FG

10

26772

10

ST041

67

109098

67

DAS

31

9-89

D3672-1

Manufactured

No

110

Each

1,658.000

24

72

DAS

33

9-89

D3672-1

Phenolic Washer

**

109098

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

1648

103845

4

112218

500

113581

500

93886

450

99099

194

DAS

31

9-89

93886

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Picklist Print

March-13-14 8:39:00 AM

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Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

AN5C35A Purchased No

110 Each 16.0000 1 3

DAS
33
9-89

AN5C35A

Bolt
DAS
CS
9-89

Location
ST338

Loc Qty

Loc Code

16

123930

6

M128374

10

110 Each 107.0000 1 3

DAS
33
9-89

AN5C15A Purchased No

AN5C15A

Bolt

Location
ST337

Loc Qty

Loc Code

57

M126180

7

M128429

50

st503

50

M127290

50

110 Each 85.0000 2 6

DAS
33
9-89

AN5C32A Purchased No

AN5C32A

BOLT

Location
FG

Loc Qty

Loc Code

4

18918

4

ST337

6

M123930

6

ST504

75

m125842

50

m126007

25

March-13-14 8:39:00 AM

Shop Packet Print

Page 13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 14

Work Order ID: 114797

114797

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 3/13/14

Required Date: 3/27/14

Start Qty: 3.00

Required Qty: 3.00

AN5C34A

Purchased

No

110

Each

6.0000

2 6

AN5C34A

Bolt

**

128669

DAS

33

9-89

DAS
CS
9-89

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

4

M126007

4

110

Each

195.0000

4

12

**

DAS

33

9-89

DAS
31
9-89

MS21043-5

Purchased

No

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

88

116548

88

ST315

87

121584

87

S
CS
9-89

DAS
31
9-89

121584

March-13-14 8:39:00 AM

Shop Packet Print

Page 14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -557	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-557	WEARSHOE KIT (REPLACES -547 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D4956-15	* WEARSHOE ⁽¹⁾ (REPLACES D3535-15 + D3536-15)
23A					1	1				D4956-23	* WEARSHOE ⁽¹⁾ (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-39	* WEARSHOE ⁽¹⁾ (REPLACES D3535-39 + D3536-39)
25A					1	1				D4956-35	* WEARSHOE ⁽¹⁾ (REPLACES D3535-35 + D3536-35)
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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Revision: Q

Date: 13.08.12

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-642

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -557	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80								1	1	D4368-041	FWD WEARPLATE ASSY
81								1	1	D4368-043	AFT WEARPLATE ASSY
82A								1	1	D4383-1	WEARPAD
82B								1	1	D4383-3	WEARPAD
83								20	20	D3873-3	BUSHING
84									24	D3411-3	WASHER
85								2		D3275-1	SPACER
86A								6	6	AN3C40A	BOLT
86B								2	2	AN3C37A	BOLT
86C								2	2	AN3C36A	BOLT
87								10	10	MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: Q
Date: 13.08.12

Work Order ID 114797

March-13-14 8:38:56 AM

114797

Page

Item ID: K642-511

Revision ID:

Item Name: Saddle 642-511

Start Date: 3/13/14 Start Qty: 3.00

Required Date: 3/27/14 Req'd Qty: 3.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

Date: 14-03-13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

P

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Create White labels per PPP K642-511 CHG005

MLJ 14-04-08

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control